

Date: Friday, 2/23/2007 8:31:01 AM  
 User: Kim Johnston

## Process Sheet

|                       |   |                  |                              |
|-----------------------|---|------------------|------------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services   | Drawing Name     | : ANGLE                      |
| Job Number            | : 30871   |                  |                              |
| Estimate Number       | : 10196   |                  |                              |
| P.O. Number           | : <i>N/A</i>  | Part Number      | : D21751                     |
| This Issue            | : 2/23/2007 S.O. No. <i>N/A</i>   | Drawing Number   | : D2175 REV E                |
| Prsht Rev.            | : NC  | Project Number   | : N/A                        |
| First Issue           | : <i>N/A</i> Type : SMALL /MED FAB  | Drawing Revision | : E                          |
| Previous Run          | : 26495   | Material         | : <i>N/A</i>                 |
| Written By            | :   | Due Date         | : 3/24/2007 Qty: 25 Um: Each |
| Checked & Approved By | : <u>07.02.23</u> <i>[Signature]</i>  |                  |                              |
| Comment               | : Est E 04.06.09 Reformat <i>KJ/RF</i><br>Est Rev:F 06-04-28 Manufactured on Water Jet JLM<br>Est Rev:G As per Rev E 06-11-22 JLM |                  |                              |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |             |                    |
|-----|-------------|--------------------|
| 1.0 | M2024T3S063 | 2024-T3 .063 sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.4958 sf(s)/Unit Total : 12.3953 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick  
 (M2024T3S.063) Batch: *M162942*

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET  
 1-Cut as per Dwg D2175  
 Dwg Rev: E  
 Prog Rev: E

*M 07 03 01*

(25)

2-Deburr if necessary

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*M 07 03 01*

(25)

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

*M 07/03/01 (25)*

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr Stack

*MF. 07-03-05*

(25)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/30

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Friday, 2/23/2007 8:31:01 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 30871

Part Number: D21751

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2175

SR 07/03/29

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-03-29

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS

07-03-29 (25)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SR

07/03/29 (28)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SR

07/03/29 (28)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/30

Job Completion



07-03-30

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

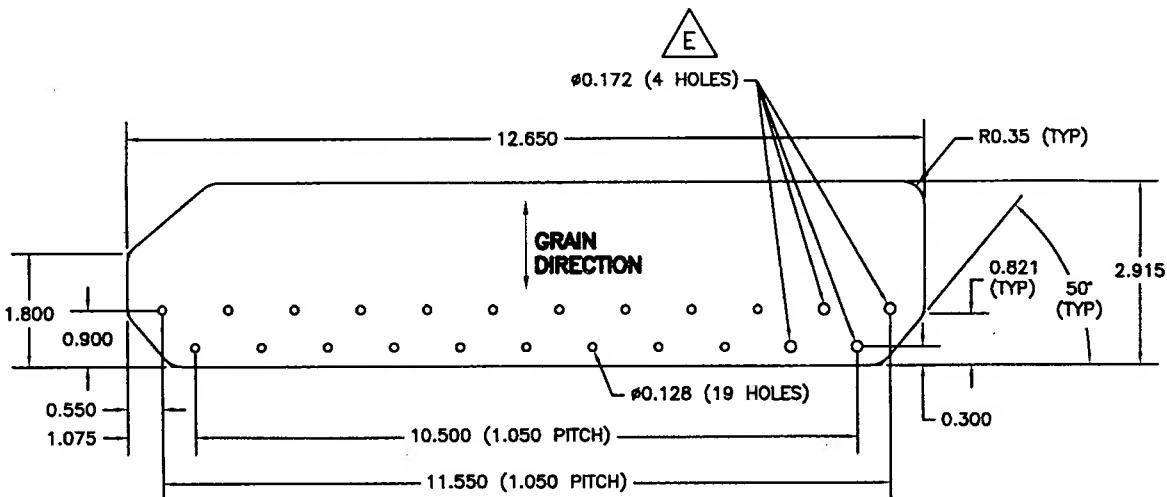
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

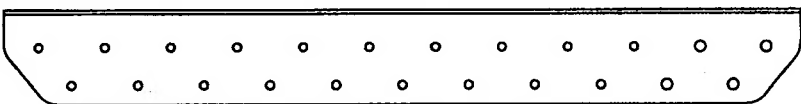


RELEASED  
06.10.13

| DESIGN           | DRAWN BY                | DART AEROSPACE LTD<br>HAMKESBURY, ONTARIO, CANADA |              |  |
|------------------|-------------------------|---|--------------|--|
| RF               | CE                      | DRAWING NO.                                       | REV. E       |  |
| CHECKED<br>PH    | APPROVED<br>[Signature] | D2175   | SHEET 1 OF 1 |  |
| DATE<br>06.09.25 | TITLE<br>ANGLE          | SCALE<br>1:3                                      |              |  |
| A                | 95.10.25                | NEW ISSUE   |              |  |
| B                | 96.01.18                | CHANGED DIMENSION                                 |              |  |
| C                | 00.09.11                | UPDATE FINISH SPEC                                |              |  |
| D                | 04.06.03                | RE-DESIGN   |              |  |
| E                | 06.09.25                | INC HOLE DIA TO Ø0.172, 4 HOLES                   |              |  |



**D2175-1F FLAT PATTERN**



**D2175-1 BEND DETAIL SHOWN  
(D2175-2 BENT OPPOSITE)**

**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
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UNCONTROLLED COPY  
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WITHOUT NOTICE

WORK ORDER  
NO. 30871

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